

Date: Friday, 22/05/2009 4:45:49 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 48155	
Estimate Number : 12736	
P.O. Number :	Part Number : D353515 <i>GY</i>
This Issue : 22/05/2009 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 47521	Material :
Written By :	Due Date : 29/05/2009 Qty: 13 Um: Each
Checked & Approved By : <u>JUD 09.05.25</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 1.0715 sf(s)/Unit Total : 13.9298 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 111571 *B 9-5-09*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: B *B 9-5-09*Prog Rev: B2-Deburr if necessary *B 9-5-09*

(13)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

*B 9-5-09***Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK*S 09/05/09*

(13)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158

3-Identify as D3535-15

SB 09/06/02

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:45:49 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 48155

Part Number: D353515

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Surf 66102 (13)

7.0

POWDER COATING

POWDER COATING



m/09091



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:05

OVEN TEMPERATURE:

320°

FINISH TIME:

8:35

FL 09/06/03

(13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09-06-03 (13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-18

FL 09/06/03

(13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/04

Job Completion



MF
09-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 48155
Description: Wearshoe		Part Number: D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.886	*			
2.000	+/-0.010	2.000	*			
5.650	+/-0.010	5.651	*			
9.150	+/-0.010	9.149	*			
14.400	+/-0.010	14.400	*			
19.650	+/-0.010	19.650	*			
24.900	+/-0.010	24.900	*			
30.150	+/-0.010	30.150	*			
33.650	+/-0.010	33.650	*			
35.650	+/-0.010	35.650	*			
39.150	+/-0.010	39.150	*			
Ø0.188	+0.005/-0.001	.191	*			
24.00	+/-0.030	24.00	*			
16.00	+/-0.030	16.00	*			
8.00	+/-0.030	8.00	*			
5.00	+/-0.030	5.00	*			
0.300	+/-0.010	.303	*			
0.300	+/-0.010	.302	*			
0.038	+/-0.010	.036	*			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-5-09	Date: 09/05/09	Date:	N/A

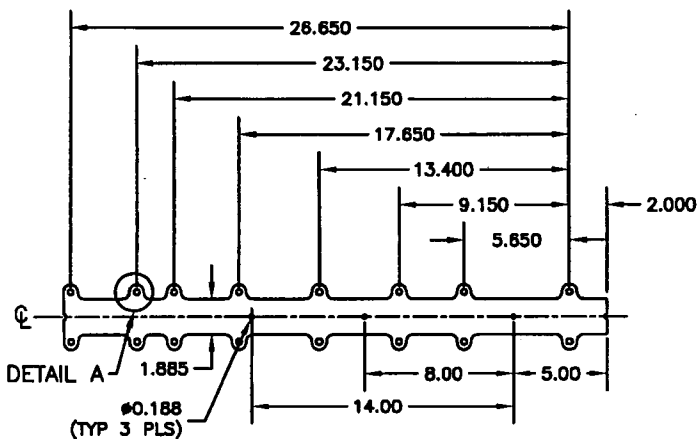
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	B

DART

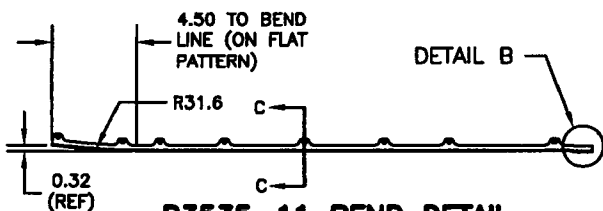
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07.04.24

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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
PH	PH	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	NEW ISSUE	SCALE
B	07.04.17	1:10
	MOVE TAB OUTBOARD, ADD AMS SPEC	



D3535-11F FLAT PATTERN

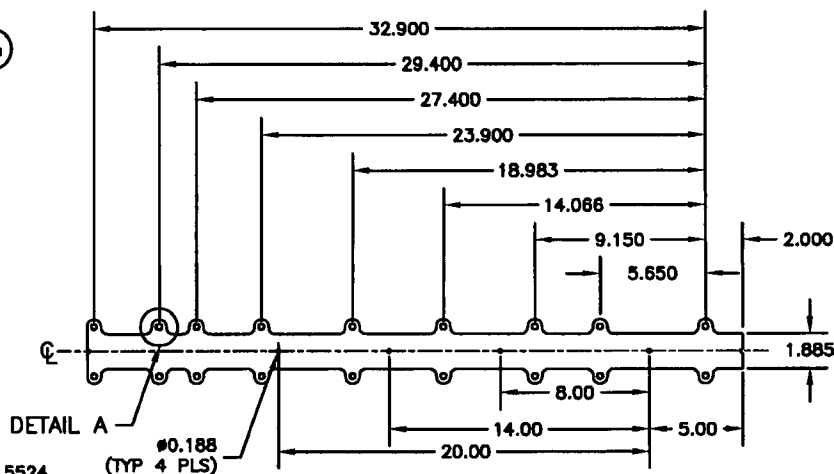


D3535-11 BEND DETAIL

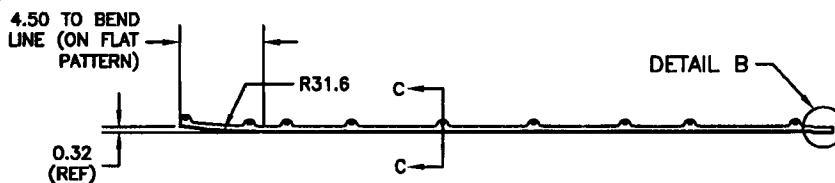
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NO. 281508

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION



D3535-13F FLAT PATTERN

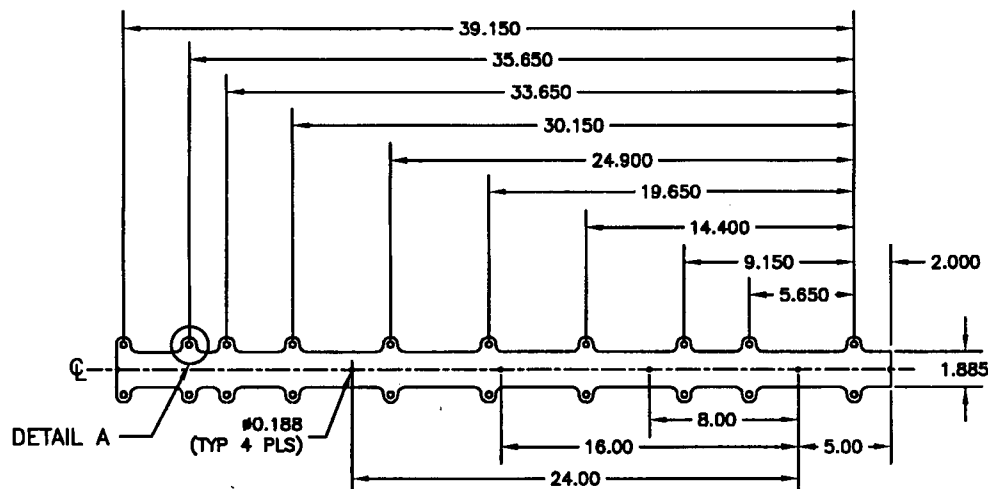
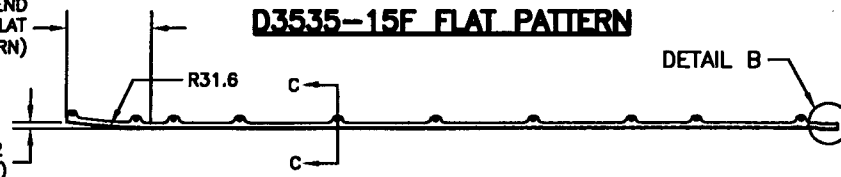
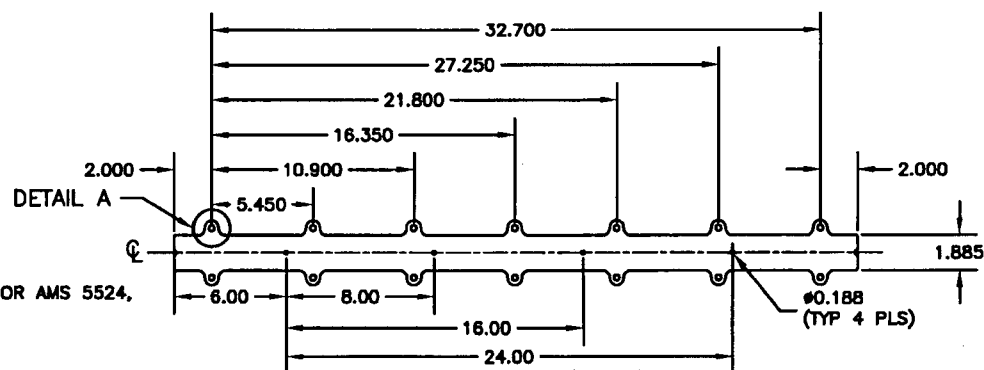


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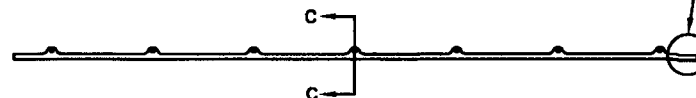
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**D3535-15F FLAT PATTERN**4.50 TO BEND
LINE (ON FLAT
PATTERN)0.32
(REF)**D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN**

DETAIL B

**D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
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- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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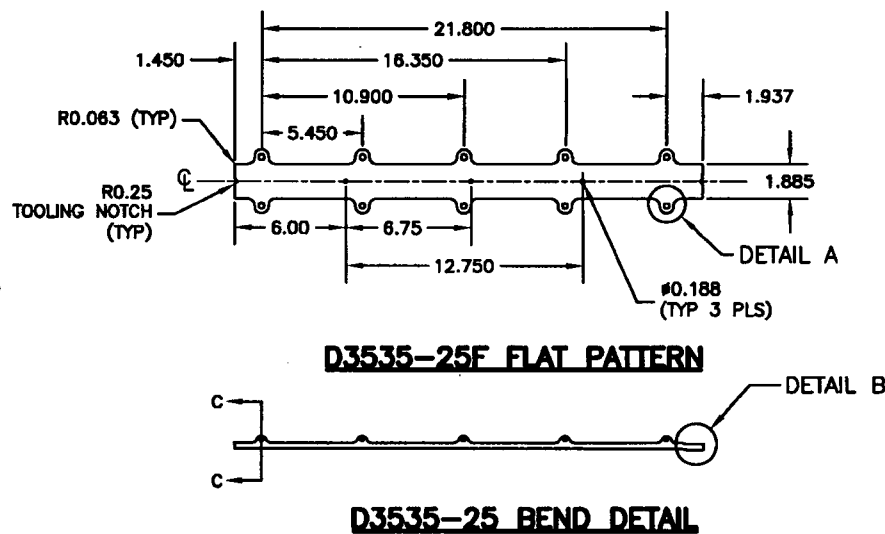
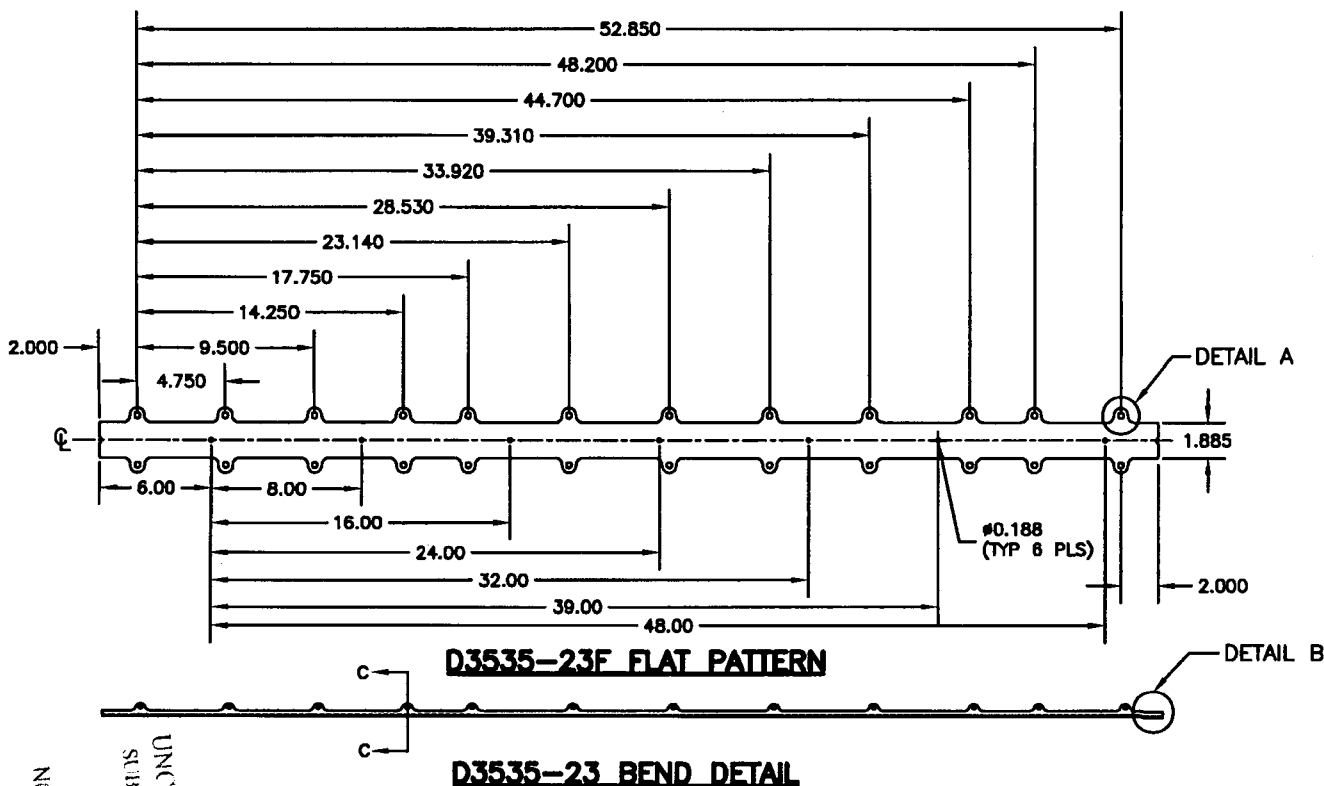
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 2 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

DART

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		TITLE	WEARSHOE	SHEET 3 OF 7
				SCALE 1:10

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NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
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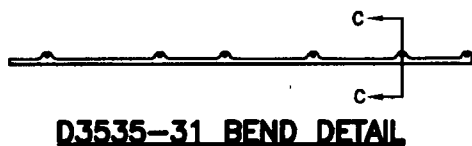
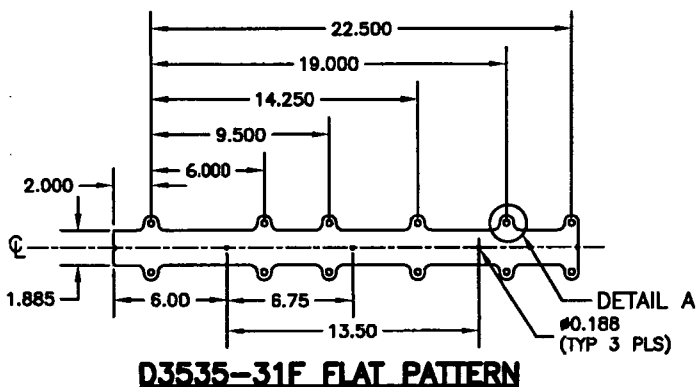
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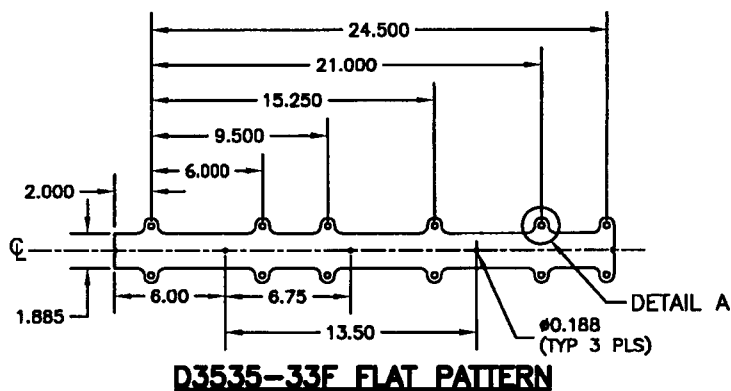
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	



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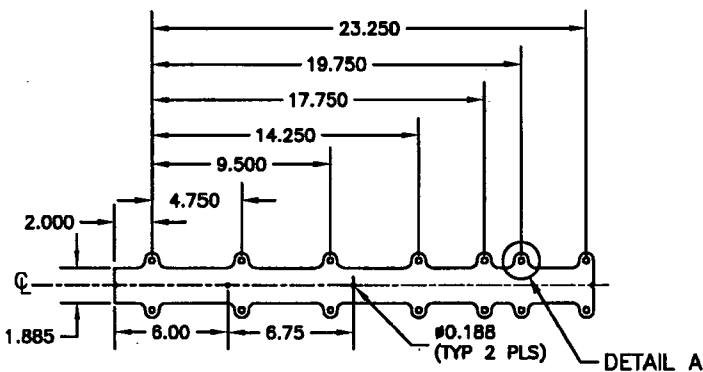
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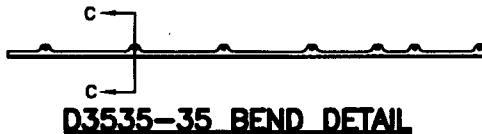
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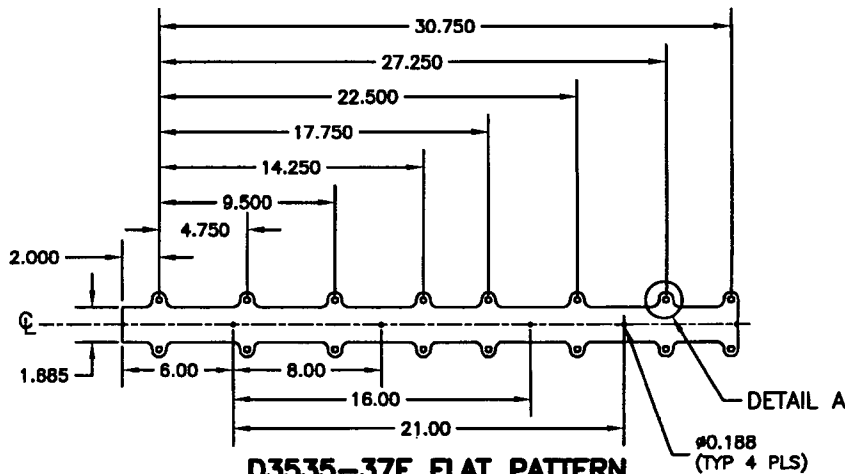
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

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NOTES

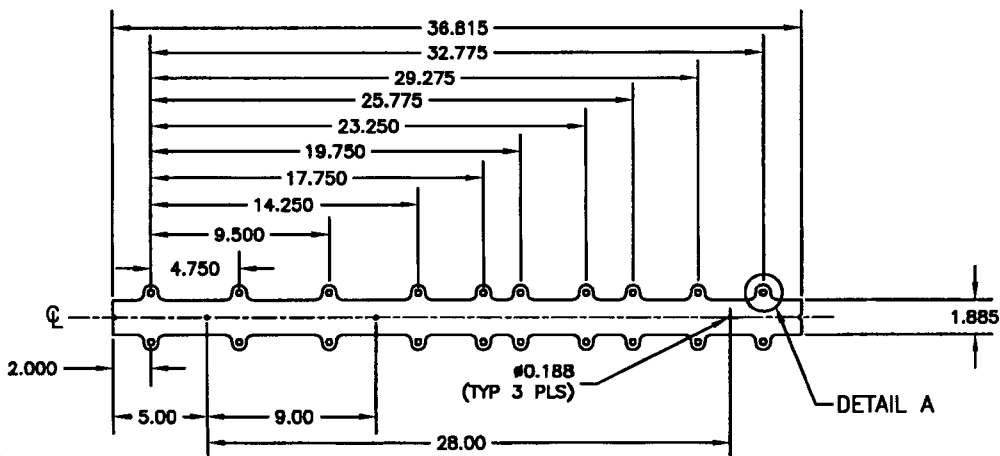
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(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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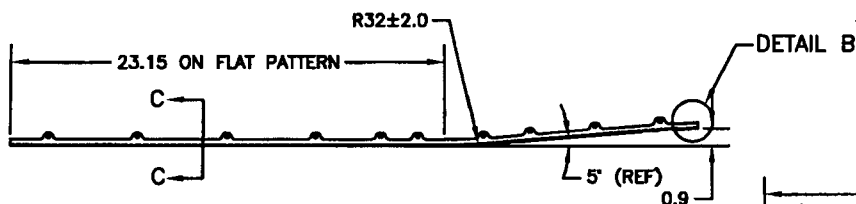
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07 04 24

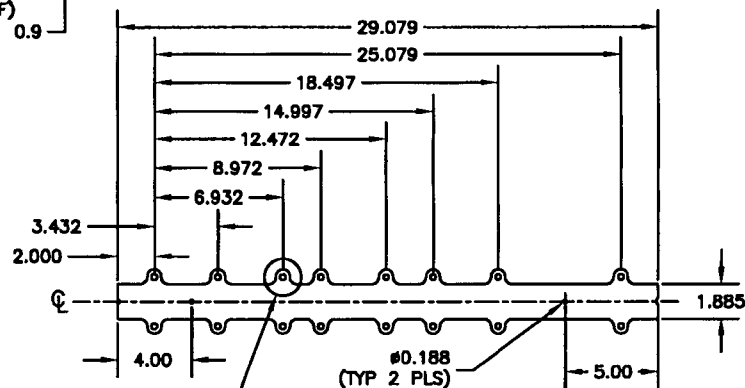
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DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



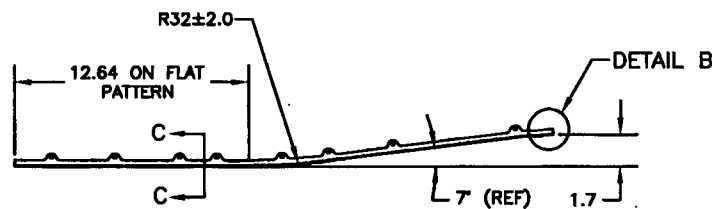
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

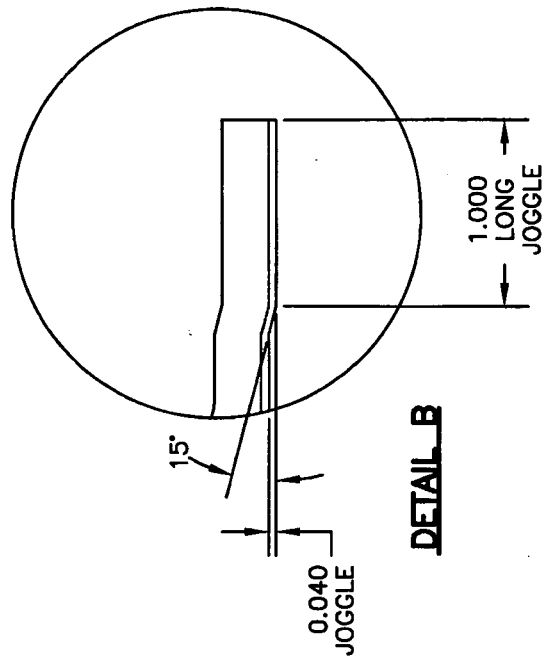
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
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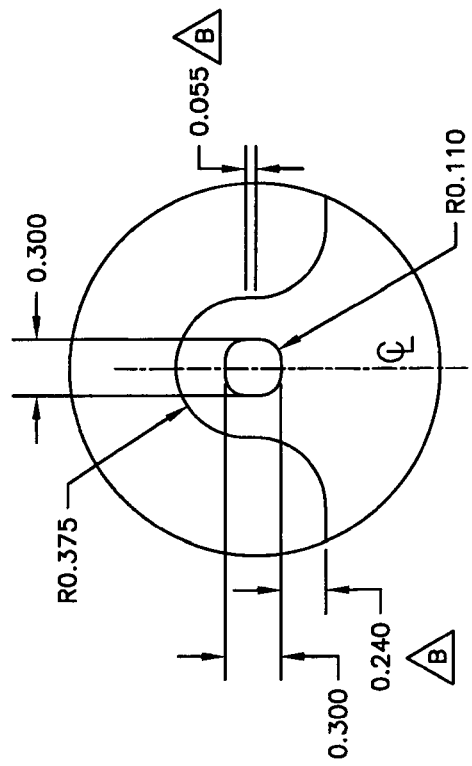


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DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

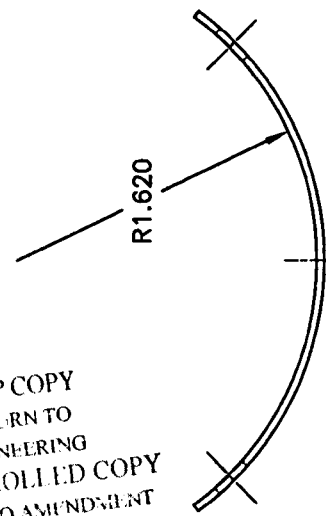
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DETAIL B



DETAIL A



SECTION C-C

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